Sherline Knurling Tool Primer

- Maximum Diameter that can be Knurled is 1”
- Knurl tool utilizes a scissor type (squeeze) holder
- Produces a 'fine' diamond pattern (25 TPI)
- Run spindle at slow speed approx 500 rpm
• The two knurling tool holders mount directly on to the T-Slots.
• Center to the workpiece and squeeze finger tight
• Tighten the holders to the slide. Do not over tighten
• Start the motor to no more than 500 RPM
• Begin to tighten the Long screws with the hex key until the diamond pattern begins to appear.
• Tighten a bit more and stop the motor to inspect the knurl. If complete then restart motor and continue. Else add a little bit more tightness (top and bottom equally).
• If the motor starts to bog down – it is too tight.
Begin feeding the knurling tool in a slow even fashion. You can pause occasionally to check your progress.
Loosen the tightening bolts before retracing the slide. Do not run the knurling tool backwards.